

Date:

Tuesday, 15/08/2006 7:19:44 AM

User: Linda Lacelle

Process Sheet

Customer

: CU-DAR001 Dart Helicopters Services

Job Number

: 28182

Estimate Number

: 10515

P.O. Number This Issue

: 1214 : 15/08/2006

: NC

Prsht Rev. First Issue

S.O. No. : ~//

Type

: 25715 **Previous Run** Written By

Checked & Approved By

Comment

: Est:

A 01.03.21

: MACHINED PARTS

New Issue EC

Project Number Drawing Revision

Drawing Number

Drawing Name

Part Number

Material **Due Date**

Description:

6061-T6 Bar 1.5" x 1.5"

: 414 : 08/09/2006

D2805 REV. B

: STOP

: D28053

: N/A

: B

Qty:

16 Um:

06/08/16

06/08/16

Each

16

16

Additional Product

Job Number:



Seq. #:

1.0

2.0

3.0

4.0

5.0

M6061T6B1500X01500

Comment: Qty.:

0.2756 f(s)/Unit

Total: 4.4100 f(s)

6061-T6 Bar 1.5" x 1.5"

Material: 6061-T6 (QQ-A-200/8 or QQ-A-250/11) 1.5" x 1.5 Batch: 1695 L

(M6061T6B1500X01500)

BAND SAW



Comment: BAND SAW

BAND SAW

Cut Bar: 3.150" Long

+0.010/-0.030"

HAAS CNC VERTICAL MACHINING #1





Comment: HAAS CNC VERTICAL MACHINING #1

1- Machine as per Folio FA104 and Dwg D2805

2- Tumble and Deburr

Identify as D2805-3 QC2

INSPECT PARTS AS THEY COME OFF MACHINI



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

QC8

Comment: SECOND CHECK

SECOND CHECK



01./08/19

Dart Aerospace Ltd

W/O:			WORK ORDER	CHANGES				
DATE	STEP	PR	OCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Category:	NCR: Yes	No DQ	A: 😭	⊵ Date: <u>↑</u>	108 V2
				QA: I	N/C Close	d:	_ Date: _	
NCR:			WORK ORDER NON-CON			<u> </u>		

NCR:		WORK ORDER NON-CONFORMANCE (NCR)								
		STEP Description of NC Section A		Corrective Action Section B						
DATE	STEP		Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector		
							I			
							:			
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							i			
							,			

NOTE: Date & initial all entries

Date: Tuesday, 15/08/2006 7:19:44 AM User: Linda Lacelle **Process Sheet Drawing Name: STOP** Customer: CU-DAR001 Dart Helicopters Services Job Number: 28182 Part Number: D28053 Job Number: **Description:** Seq. #: **Machine Or Operation:** HAND FINISHING1 HAND FINISHING RESOURCE #1 6.0 Comment: HAND FINISHING RESOURCE #1 Acid etch and Alodine as per QSI 005 4.1 INSPECT POWDER COAT/CHEMICAL CONVERSION 7.0 QC3 Comment: INSPECT ALODINE PACKAGING 1 PACKAGING RESOURCE # 8.0 Comment: PACKAGING RESOURCE #1 Identify and Stock Location: ST387 DOCUMENT CONTROL 9.0

Comment: DOCUMENT CONTROL Inspection Level 21

1 2608.73

Job Completion

Dart Aerospace Ltd

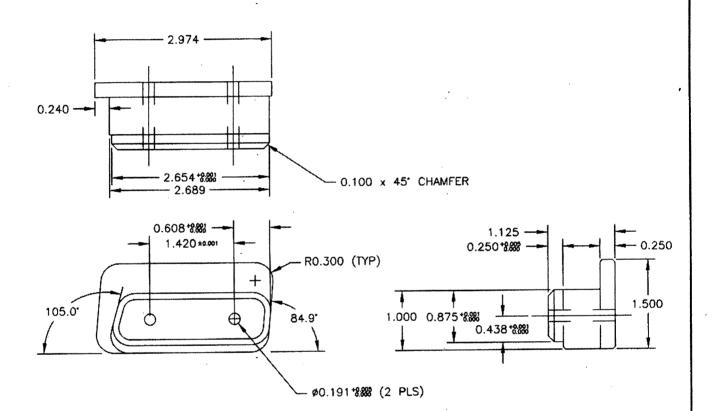
W/O:			WC	ORK ORDER CHANG	ES				
DATE	STEP	PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
•									
Part No	:	PAR #:	Fault Cate	gory:	NCR: Yes	lo DQ	A:	Date:	
								Date: _	
NCR:		1	WORK ORDI	ER NON-CONFORMA	NCE (NCR)	1			
DATE	STEP	Description of NC Corrective Action Section				Verification		Approval	Approval
DATE		Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector	
									ļ.

									:

NOTE: Date & initial all entries



	DESIG	N may	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
	CHECK	(ED	APPROVED	DRAWING NO. R	EV. B
-		#	#	D2805 SHEET 1	OF 2
-	DATE			TITLE	SCALE
	01.0	3.13		STOP	2:3
	Α		00.10.31	NEW ISSUE	
	R		01.03.13	ADD -3/-4	



REFERENCE ONLY

D2805-1 (SHOWN) D2805-2 (OPPOSITE)

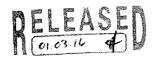
BREAK ALL OUTSIDE EDGES 0.030 TO 0.060 UNLESS OTHERWISE NOTED. BREAK ALL INSIDE EDGES 0.005 TO 0.015 UNLESS OTHERWISE NOTED. MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) FINISH: CHEMICAL CONVERSON COAT PER DART QSI 005 4.1 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

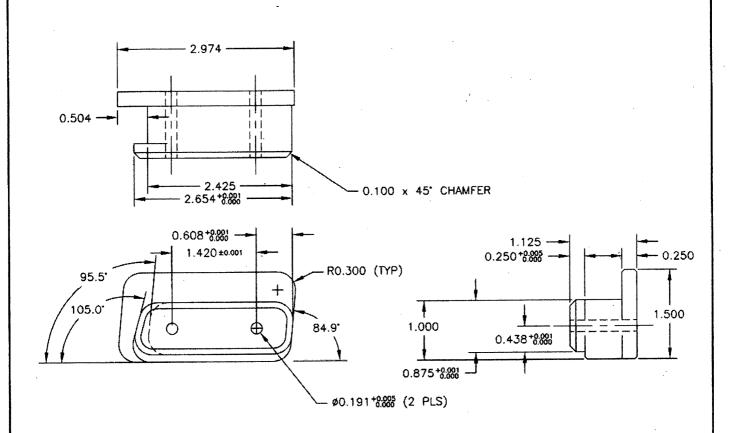
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DESIGN	DRAWN BY		ROSPACE LTD IRY, ONTARIO, CANADA
CHECKED,	APPROVEQ	DRAWING NO.	ŘĚV. B
CH CH	9	D2805	SHEET 2 OF 2
DATE		TITLE	SCALE
01.03.13		STOP	2:3





D2805-3 (SHOWN) D2805-4 (OPPOSITE)

BREAK ALL OUTSIDE EDGES 0.030 TO 0.060 UNLESS OTHERWISE NOTED. BREAK ALL INSIDE EDGES 0.005 TO 0.015 UNLESS OTHERWISE NOTED. MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) FINISH: CHEMICAL CONVERSON COAT PER DART QSI 005 4.1 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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DART AEROSPACE LTD	Work Order:	28/82
DART AERUSPACE LID	4.4	
Description: STAP	Part Number:	122805-3
Description: STOP		
Inspection Dwg: DORAG, Rev. R		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article X Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Rejest	Method of Inspection	Comments
2.974	±.010	2.974	,			
0.504	±.010	0.509				
0.100×45°	±-016	0.09414 48			. •	
2.425	+016	2.425				·
2.654	± .001 = .000	2.654			'	
0.608	+·001	0.609				
1. 430	=,001	1.419				
80.191	+ .005	0.195				
1.125	±,016	1.122				
0.250	+.005	0,250				
0.250	±,010	0.248				
1,500	+010	1.498				
0.875	+-001	0.8.75				
0.438	-· 00D	0.438				
1-000	÷-010	1.000	~			
						:
		4				

Measured by:	I In	Audited by: J.L	Prototype Approval:	
Date:	0/0/08/19	Date: 06/6	8/19 Date:	10/11

Rev	Date	Change	Revised by	Approved
Δ	Date	New Issue	KJ/JLM	

